

**Work Order ID 70373**

Monday, June 06, 2011 8:43:59 AM



Page 1

Item ID: D4016-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Lid

Start Date: 6/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *PH*Date: *11-06-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4016	A								
100	Cut blanks as per folio	0.00							
Bandsaw	Memo	0.00	<i>B.A</i>	<i>11/06/07</i>		<i>6</i>	<i>0</i>		
Jeaspa Bandsaw	CUT BLANK as per folio								
110		0.00							
HAAS 1	Memo	0.00	<i>B.A</i>	<i>11/06/09</i>		<i>6</i>	<i>0</i>		
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA874 AND DWG FOLIO REV: <i>AA</i> DWG REV: <i>A</i>  DEBURR								

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		HA 11/06/09		6	0		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		20 11.2.10		6			
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>P250</u>  Memo	0.00  0.00							P04/4/13 (6)

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Accept



Setup Start



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Stop



Item Name: Hinge Half, Lid

Start Date: 6/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13

CL1106113

# Picklist Print

Monday, June 06, 2011 8:44:06 AM

Page 1

Work Order ID: 70373



Parent Item: D4016-3



Parent Item Name: Hinge Half, Lid

Start Date: 6/6/2011

Required Date: 6/10/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as  
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	11.7440	0.08	0.505263			

304 bar 1.00 x 1.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT050	11.744	
113290	1.047	
117130	10.697	

0.5052

LA 11/06/07

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	70373
<b>Description:</b> Hinge Half, Lid		<b>Part Number:</b>	D4016-3
<b>Inspection Dwg:</b> D4016 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

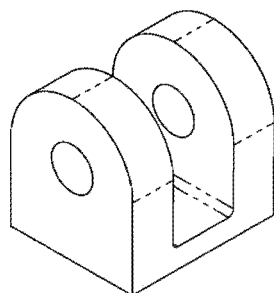
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.13	+/-0.030	0.127	✓		"	"
0.250	+/-0.010	0.248	✓		"	"
R0.03	+/-0.030	R0.032	✓		R-G	ref.
0.13	+/-0.030	0.125	✓		Vern	GA-01
0.50	+/-0.030	0.496	✓		"	"
0.63	+/-0.030	0.626	✓		"	"
0.563	+/-0.010	0.562	✓		"	"
Ø0.257	+0.006/-0.001	0.259	✓		"	"

<b>Measured by:</b> J. A.	<b>Audited by:</b> RQ	<b>Preliminary Approval:</b>
<b>Date:</b> 11/06/09	<b>Date:</b> 11.6.10	<b>Date:</b>

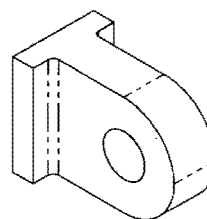
Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	JA

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 70373

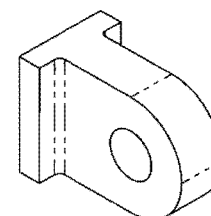
*PH-06-6*



D4016-1 HINGE HALF, BASE



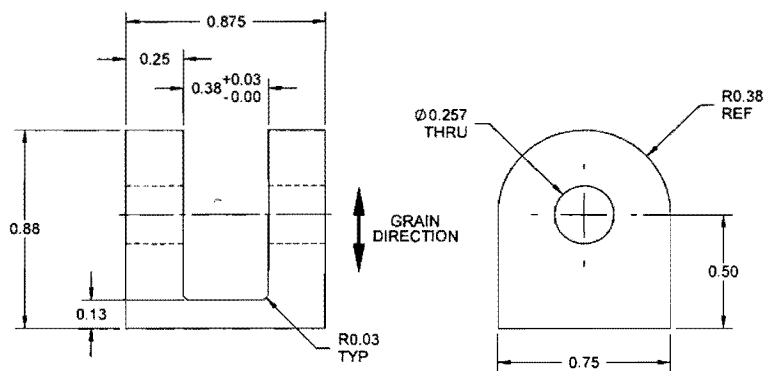
D4016-3 HINGE HALF, LID



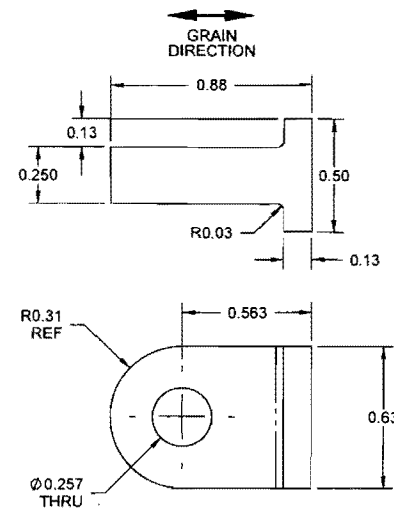
D4016-5 HINGE HALF, LIGHT LID

**RELEASED**  
 2010-02-16  
*MD*

A	NEW ISSUE	JPH	10.01.29
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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**D4016-1 HINGE HALF, BASE**



**D4016-3 HINGE HALF, LID**

**D4016-5 HINGE HALF, LIGHT LID**

**NOTES:**

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

**RELEASED**  
2010-02-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4016</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET HINGE</b>	NTS
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